

Date: Friday, 13/02/2009 1:02:25 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HINGE BRACKET
<b>Job Number</b> : 45788	
<b>Estimate Number</b> : 10345	
<b>P.O. Number</b> :	<b>Part Number</b> : D28571
<b>This Issue</b> : 13/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2857 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 41166	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 24 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson</u>	
<b>Comment</b> : Est C 00.06.22 Removed P/O for powder coat EC Est D 06.05.01 Added level 8 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.00 x 1.25
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**Comment:** Qty.: 0.4594 f(s)/Unit Total: 11.0250 f(s)  
 Material: 2.00" X 1.25"  
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
 (M6061T6B200001250)  
 Batch M100451

25

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks 5.2"

25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2857-1  
 2-Deburr any rough edges

25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/02/2009 1:02:25 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 45788

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/02/18

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

BL 09-02-18 (25)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Force 18

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M109996

START TIME: 2:20pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:50pm

HL 09-02-18 (25)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/02/18 (25)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST01

09/2/19 (25)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2009

Job Completion



MF 09-02-19

-W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 45788
Description: Hinge Bracket		Part Number: D2857-1
Inspection Dwg: D2857	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓			
4.000	+/-0.010	4.000	✓			
0.340	+/-0.010	.339	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.319	✓			
2.000	+/-0.010	2.000	✓			
0.340	+/-0.010	.340	✓			
0.447	+/-0.010	.447	✓			
Ø.171	+0.005/-0.000	Ø .174	✓			
0.147	+/-0.010	.147	✓			
0.376	+/-0.010	.374	✓			
0.126	+/-0.010	.120	✓			
0.063	+/-0.010	.063	✓			
Ø.166	+0.005/-0.000	Ø .166	✓			
0.911	+/-0.010	.911	✓			
0.600	+/-0.010	.603	✓			
0.125	+/-0.010	.123	✓			
0.150	+/-0.010	.148	✓			

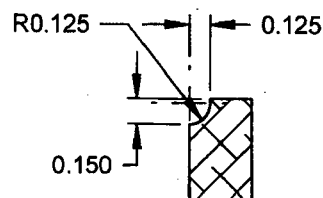
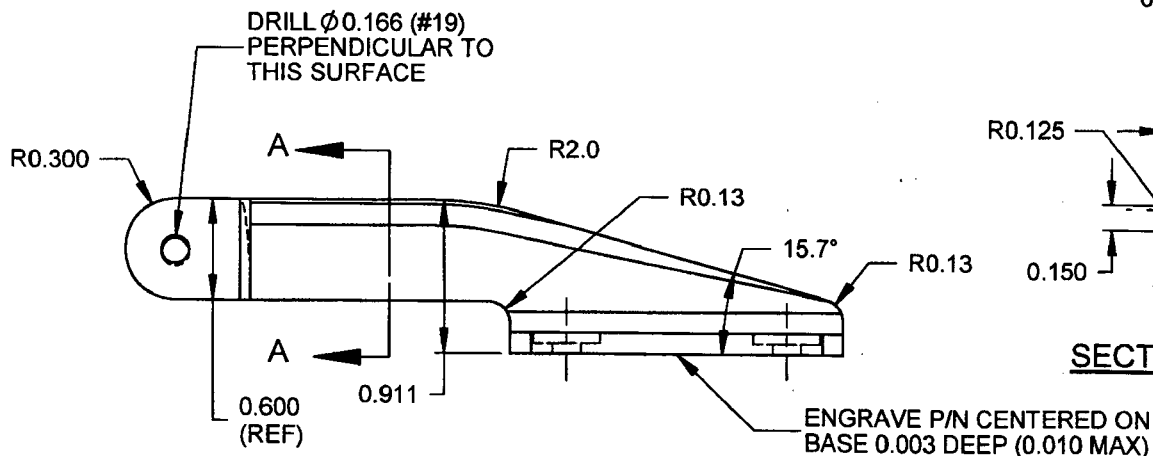
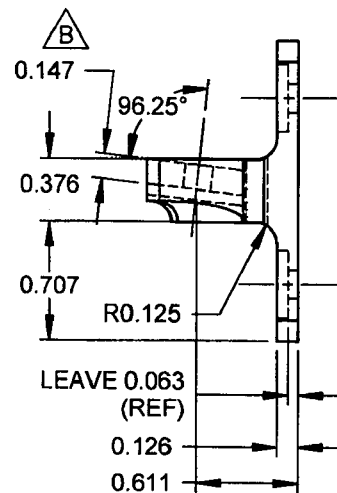
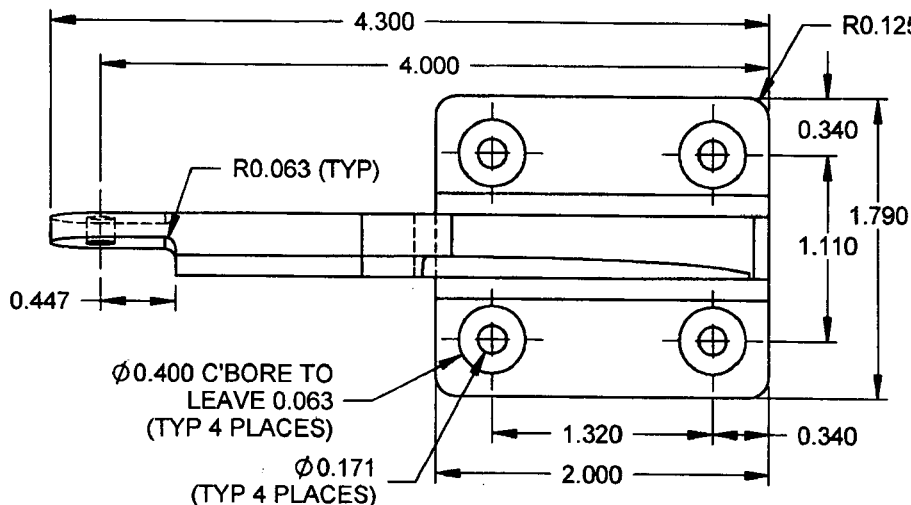
Measured by: mnt-	Audited by: J.L	Prototype Approval:	N/A
Date: 09/02/18	Date: 09/02/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	



DESIGN KE	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	SHEET 1 OF 1
DATE <b>06.08.28</b>	TITLE <b>HINGE BRACKET</b>	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

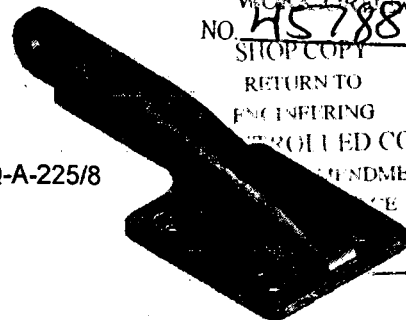
RELEASED  
06-10-13



**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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